



Dart Aerospace Ltd.  
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RBE117-68021W8-3  
Job Sheet 185133



Part No: RBE117-68021W8-3

Job Qty: 4 ea

Part Name: Press



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/23/18

Job Tracking No:

Due Date: 11/23/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE117-68021W8 Rev. 1 IPP Rev. A 18.09.28 New issue DP Verify DD

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation          | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off      |
|-------|--------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|---------------|
|       |                    |       |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |               |
| 90    | Start up Operation | 4 Ea  | 11/23/18   | 11/23/18 | 0.00      | 0.00    | Start Up Machining-3  |           | SB - 18.12.20 |
| 110   | CNC Lathe          | 4 pcs | 11/23/18   | 11/23/18 | 0.00      | 2.00    | MORI SL-154           |           | JB - 18.12.20 |
| 120   | QC                 | 4 pcs | 11/23/18   | 11/23/18 | 0.00      | 0.00    | QC2 Machining-4       |           | JB - 18.12.20 |
| 130   | QC                 | 4 pcs | 11/23/18   | 11/23/18 | 0.00      | 0.00    | QC8 Machining-4       |           | JB - 18.12.20 |
| 140   | Packaging          | 4 pcs | 11/23/18   | 11/23/18 | 0.00      | 0.00    | Packaging3-1          |           | JB - 18.12.20 |
| 150   | QC21-SA            | 4 Ea  | 11/23/18   | 11/23/18 | 0.00      | 0.00    | QC21                  |           | JB - 18.12.20 |

Part Op Descriptions: 110 - 1-Machine as per DWG. FC425 FOLIO REV: \_\_\_\_\_ DWG REV: 1 2-Debur

### Job BOM

| Part / Item | Component Name       | Quantity            | Operation             | Container          |
|-------------|----------------------|---------------------|-----------------------|--------------------|
| M303R0.625  | 303 Round Bar 0.625" | 1.5000 ft (.375 ea) | 90-Start up Operation | S110762<br>S108976 |

### Job Allocations

| Operation             | Component Part | Required | Inventory | Allocated |
|-----------------------|----------------|----------|-----------|-----------|
| 90-Start up Operation | M303R0.625     | 2        | 27        | 0         |

### Part Specifications

Specifications could not be found.



Container No: S139528



Part: RBE117-68021W8-3

Job No: 185133

Serial No/Batch: S139528

Revision: 1

Inspector:

Exp Date:

Instructions:

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Plex 10/23/18 8:59 AM Dart.lajeunesse.marie

Date: 12/20/18



DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

|                   |                                                                                                                                                                                |                                        |                                     |                                              |                                      |
|-------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------|-------------------------------------|----------------------------------------------|--------------------------------------|
| Work Order: _____ | <b>DISPOSITION</b><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Suspected Unapproved <input type="checkbox"/> | <b>AGAINST DEPARTMENT/PROCESS</b>      |                                     |                                              |                                      |
| Part No. _____    |                                                                                                                                                                                | Skid-tube <input type="checkbox"/>     | Cross tube <input type="checkbox"/> | Water Jet <input type="checkbox"/>           | Engineering <input type="checkbox"/> |
| NCR No. _____     |                                                                                                                                                                                | Machining <input type="checkbox"/>     | Small Fab <input type="checkbox"/>  | Prod. Eng. Coord. <input type="checkbox"/>   | Quality <input type="checkbox"/>     |
|                   |                                                                                                                                                                                | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/>  | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/>       |
|                   |                                                                                                                                                                                | Large Fab <input type="checkbox"/>     | Composite <input type="checkbox"/>  | Supplier <input type="checkbox"/>            |                                      |

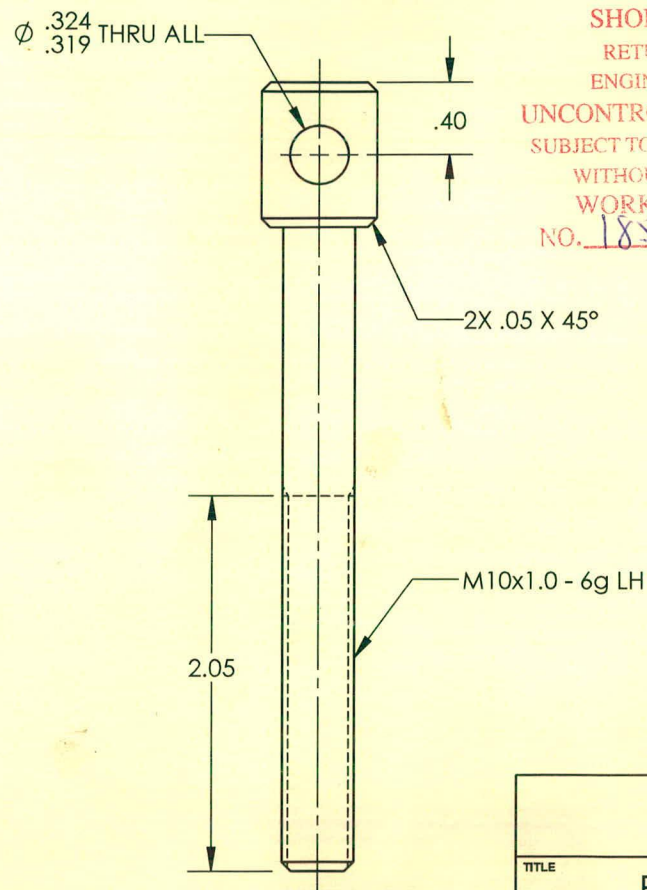
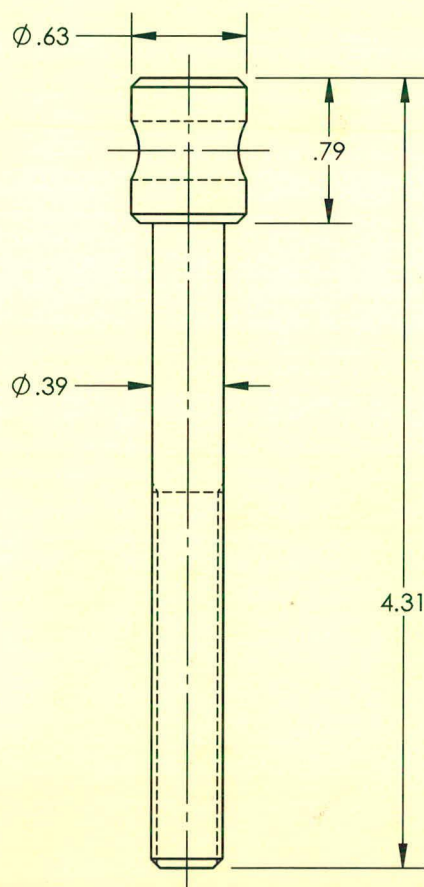
Date : \_\_\_\_\_ Step #: \_\_\_\_\_ QTY Effective : \_\_\_\_\_ MRB (QSI042) Approval \_\_\_\_\_

| Description Work Order Deviation | Disposition | Completed By                                 |
|----------------------------------|-------------|----------------------------------------------|
|                                  |             | Lead hand / Supervisor Approval Verification |
|                                  |             | QC / QA Coordinator Approval                 |
|                                  |             |                                              |

| Root Cause                                  |                                                | FAULT CATEGORY                                             |                                                |
|---------------------------------------------|------------------------------------------------|------------------------------------------------------------|------------------------------------------------|
| Environment <input type="checkbox"/>        | No Re-verification <input type="checkbox"/>    | Temperature/Cure <input type="checkbox"/>                  | Power Loss/Surge <input type="checkbox"/>      |
| Design <input type="checkbox"/>             | Operator <input type="checkbox"/>              | Set-up <input type="checkbox"/>                            | Folio/Program <input type="checkbox"/>         |
| Doc/Data <input type="checkbox"/>           | Offset/Setup <input type="checkbox"/>          | BOM/Route <input type="checkbox"/>                         | Grain <input type="checkbox"/>                 |
| Equip/Tooling <input type="checkbox"/>      | Supplier <input type="checkbox"/>              | Broken/Damage/Defect <input type="checkbox"/>              | Weld <input type="checkbox"/>                  |
| Handling/Pre <input type="checkbox"/>       | Training <input type="checkbox"/>              | Inspection Incomplete/Unqualified <input type="checkbox"/> | Wrong Stock Pulled <input type="checkbox"/>    |
| Material <input type="checkbox"/>           | Use for Testing <input type="checkbox"/>       | Contamination <input type="checkbox"/>                     | Out of Sequence <input type="checkbox"/>       |
| Internal Transport <input type="checkbox"/> | Poor Information <input type="checkbox"/>      | Countersink <input type="checkbox"/>                       | Off-set <input type="checkbox"/>               |
| Tribal Knowledge <input type="checkbox"/>   | Rushing <input type="checkbox"/>               | Cut Too Short <input type="checkbox"/>                     | Mislabeled <input type="checkbox"/>            |
| LOA <input type="checkbox"/>                | Product Improvement <input type="checkbox"/>   | Instructions Incomplete/Unclear <input type="checkbox"/>   | Fit/Function <input type="checkbox"/>          |
| Substation <input type="checkbox"/>         | Process Improvement <input type="checkbox"/>   | Drill Holes <input type="checkbox"/>                       | Misaligned/off center <input type="checkbox"/> |
| Past Expiry Date <input type="checkbox"/>   | Manufacturing Process <input type="checkbox"/> |                                                            |                                                |
| Misidentified <input type="checkbox"/>      | Past Due <input type="checkbox"/>              | OTHER : _____                                              |                                                |

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| REV |  |  | DESCRIPTION |  | DATE | INITIAL | APPROVED |
|-----|--|--|-------------|--|------|---------|----------|
|     |  |  |             |  |      |         |          |



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 185733 *HW*

*187023*



(-3)

PRESS

|                                    |                                                        |
|------------------------------------|--------------------------------------------------------|
| <b>DART<br/>AEROSPACE</b>          |                                                        |
| TITLE<br><b>PULLER (SLT61RM14)</b> |                                                        |
| DWG NO.<br><b>RBE117-68021W8-3</b> | REV<br><b>1</b>                                        |
| MAT'L S.S. 303                     | UNLESS OTHERWISE SPECIFIED<br>DIMENSIONS ARE IN INCHES |
| FEAT                               | .XXX ± .005 FRACTIONS ± 1/8                            |
| TREAT                              | .XX ± .01 ANGLES ± 5°                                  |
| FINISH                             | .X ± .1 SURFACES = 125/✓                               |
| SPEC                               | 1. BREAK ALL SHARP EDGES<br>.015 x 45° OR .015R        |
| DRAWN BY: MACKOVJAK                | 2. DIMENSIONAL LIMITS APPLY<br>AFTER PLATING           |
| CHECKED: DUERFELDT                 | 3. INTERPRET DIM AND TOL PER<br>ASME Y14.5M-2009       |
| OPPS APPR: ANDERSON                | USED ON MODEL                                          |
| QA APPR: LINDSAY                   | H175                                                   |
| APPROVED: GILBERT                  |                                                        |
| SCALE 1:1                          | DATE 7/21/2016 SHEET 3 OF 4                            |







CO.  
P.

MI  
SO  
ML